

SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 21: 3:45:50 PM  
 User: Johnston

## Process Sheet

Cutter	: CU-D	01 Dart Helicopters Services	Drawing Name	: D2530	REVISION
Job Number	: 25825	-2	Part Number	: D2530	
Est. No.	: 10333		Drawing Number	: D2530	B
P.C. Issue	:		Project Number	: 113	
This Date	: 2/15/16	S.O. No. : N/A	Drawing Revision	: B	
Prev. Job	: NC		Material	: N/A	
Fire Date	: N/A	Type : SMALL /MED FAB	Due Date	: 2/28/16	0:00
Prev. Job Run	: 24870		UoM	Each	
Written By	See COMMENT Below				
Checked & A.	Spd	06-02-16			
Comments	: Est Rev:E Removed Purchasing 06-02-16 JLM				
Add. Info					

Job Order: 

Machine Or Operation:  Description :

1.0 25825A LOCK PLATE



Cont: Sub-Component LOCK PLATE

2.0 M304TR0750W049 304 RD Tube .750 x .049W



Cont: Qty: 0.4809 f(s)/Unit Total: 9.6180 f(s)  
 Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: 414193 M100138

SAP 06:02:22 11 (1)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Cont: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

SAP 06:02:13

4.0 D2534 Lock Plate



SAP 06:02:22 19

Cont: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	B24876A

CPL 06-02-23 8

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Cont: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

CPL 06-02-23

8 9



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job No: 25825

Part Number: D2530



Line # Machine Or Operation:

Description:

2-Deburr

QC59

WELD INSPECTION



Line # Agent: WELD INSPECTION

POWDER COATING

POWDER COATING

DA 09/02/27 (8)



Line # Agent: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9-20 06-02-28

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Line # Agent: INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING 1

PACKAGING RESOURCE #1

DA 08/02/28 (8)



Line # Agent: PACKAGING RESOURCE #1

Identify and Stock

Location: St 183

10-0 DOCUMENT CONTROL

DA 06/02/28 (8)



Line # Agent: DOCUMENT CONTROL

Inspection Level 21

DA 06/03/01



DA 06-03-01



**DART**

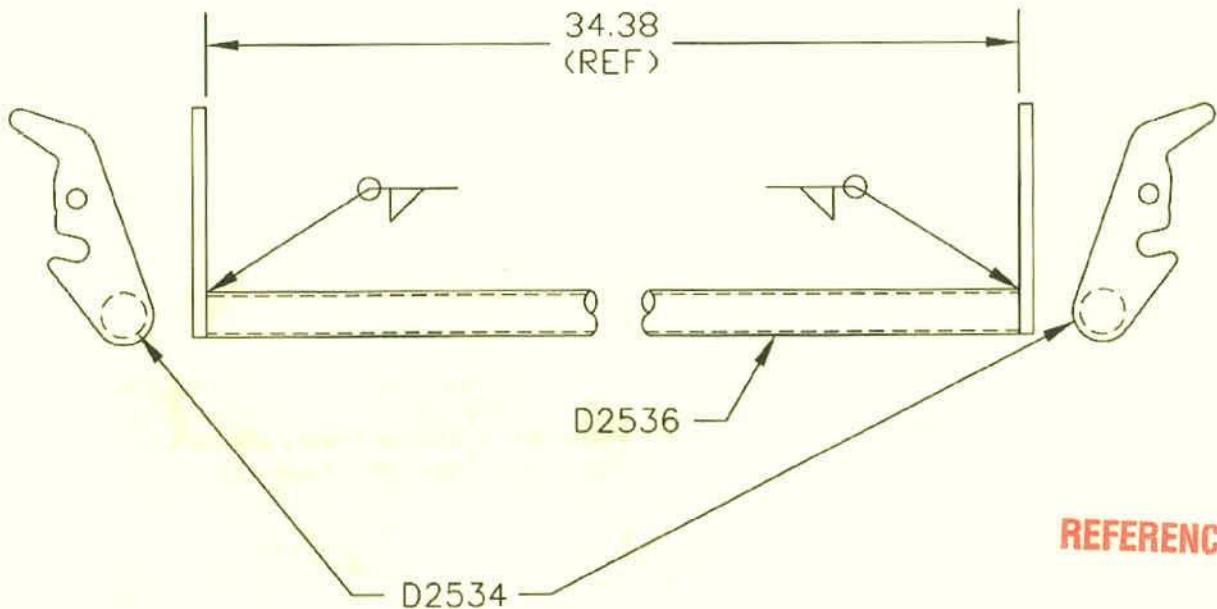
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530
		REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT
A	96.06.18	SCALE NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

